



Dart Aerospace Ltd.
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D3531-3
Job Sheet 173429



Part No: D3531-3

Job Qty: 4 ea

Part Name: Bracket Front Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 3/8/18

Type: SOLD

Description:

Note: DWG REV B SHEETS 4,5 IPP Rev:A New Issue 07-09-24 EC verified by DD IPP REV:B 12.10.24 PER DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/7/18	0.00	0.00	Start Up Waterjet		SC 18/03/04
100	Waterjet	4 pcs		3/7/18	0.00	0.26	Waterjet1		SC 18/03/04
120	QC	4 pcs		3/7/18	0.00	0.00	QC8		38
140	Brake NC	4 pcs		3/7/18	0.03	0.38	Brake NC 2		SA DAS9-89
150	QC	4 pcs		3/7/18	0.00	0.00	QC5		38
160	HandFinish	4 pcs		3/8/18	0.00	0.21	HandFinish1		SA 18-03-08
170	QC	4 pcs		3/8/18	0.00	0.00	QC7-2		38
180	Packaging	4 pcs		3/8/18	0.00	0.00	Packaging3-1	6A/29	DAS 1-89
190	QC21-SA	4 Ea		3/8/18	0.00	0.00	QC21		21 DAS 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.5252 sf (.1313 ea)	90-Start up Operation	

5010884 66

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	1	234	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation			Disposition		



Container No: S047658
 Part: D3531-3
 Job No: 173429
 Serial No/Batch: S047658
 Revision: _____
 Inspector: _____
 Date: 03/04/18

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Root Cause		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentr. ☐ Cracks ☐ Crimp/Kink/Ripple/W. ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____

☐ Incomplete/unclear
☐ Misaligned/off center

☐ Finish
☐ Misread
☐ Turning Sequence

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Front Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0.129	Diameter
2	Bracket Front Plate	3.720Inches ± 0.030	3.750 3.690	3.722	
3	Bracket Front Plate	0.370Inches ± 0.030	0.400 0.340	0.373	
4	Bracket Front Plate	2.840Inches ± 0.010	2.850 2.830	2.842	
5	Bracket Front Plate	0.880Inches ± 0.030	0.910 0.850	0.8805	
6	Bracket Front Plate	3.500Inches ± 0.030	3.530 3.470	3.501	
7	Bracket Front Plate	4.670Inches ± 0.030	4.700 4.640	4.670	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																